



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBW895-3101-04-117-09
Job Sheet 199614



Part No: RBW895-3101-04-117-09

Job Qty: 2 pcs *5*

Part Name: All Thread



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/14/19

Description:

Type: SOLD

Note: DWG RBW895-3101-04-117 Rev 1 IPP Rev. A 19.08.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Conventional Lathe - 1	2 pcs		10/14/19	0.00	0.50	Conventional Lathe - 1		<i>//</i>
							Conventional Lathe - 2		
110	QC 2	2 pcs		10/14/19	0.00	0.00	QC 2 - 1		<i>// 19/9/30</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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Container No: S218408



Part: RBW895-3101-04-117-09

Job No: 199614

Serial No/Batch: S218408

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 09/30/19

1.6419

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8/28/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
115	Conventional Mill - 1 - B4B	2 pcs	10/14/19	0.00 0.20	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
120	QC 2	2 pcs	10/14/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
					QC 2 - 66
					QC 2 - 64
					QC 2 - 65
					QC 2 - 5
					QC 2 - 71
					QC 2 - 73
					QC 2 - 69
130	QC 8	2 pcs	10/14/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8

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				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140	Packaging 3-1 - Stock - B4B	2 pcs	10/14/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
150	QC 21 - SA	2 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Manufacture as per dwg) 1-Machine as per DWG. DWG REV: <u>1</u> 2-Deburr Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 115 - (Manufacture as per dwg) 1-Machine as per DWG. 2-Deburr 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location: <u>MLL</u>) 150 - (QC21- Final Inspection - Work Order Release) <u>D 135 SF</u> <u>D 136 QC5</u>					
Job BOM					
Part / Item Component Name		Quantity	Operation	Container	
90024A232 18-8 Stainless Steel Threaded Rod, M10 X 1.5 mm Thread Size, 500 mm Long <u>(19.685" long)</u>		.4820 (.241 ea)	100-Conventional Lathe - 1	<u>S215734</u>	

DAS
28
9-89

DAS
21
9-89

OCT 1 1 2019

GA170

DAS
03
9-89

8/28/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	90024A232	0	0	0
Part Specifications				
Specifications could not be found.				

DAS
03
9-09
40

115

135

RBW895-3101-04-117-11 Plex 8/28/19 11:30 AM Dart.lajeunesse.marie

98296A879

① each 5218979
① each 5210614

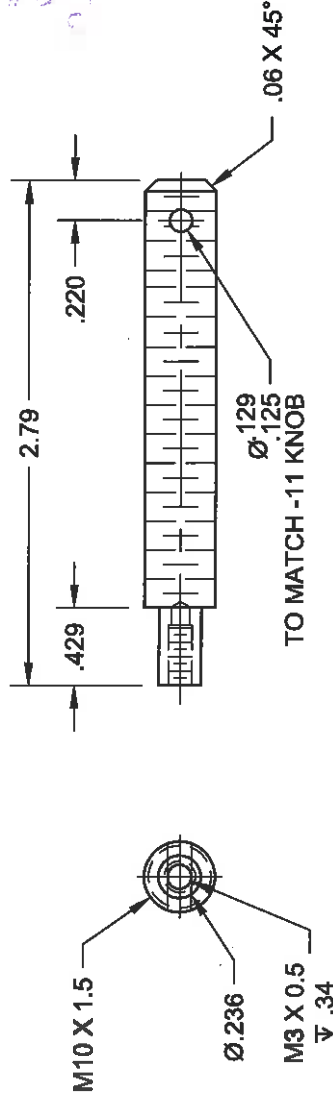
INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-09 MOVED TO SEPARATE SHEET. CHD DIM WAS Ø.130 IS LIMITS Ø.125-.129.	2/14/14	DPD	GE

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
199614
19-08-28



RED BARN MACHINE

TITLE M/R BLADE BLOCKING AND
PROTECTOR TOOL

DWG NO. RBW895-3101-04-117-09 REV 1

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS .XXX ± .005
FRACTIONS ± 1/32
ANGLES ± .5°
SPEC

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL UNITS APPLY AFTER PLATING

SCALE 1:1 DATE 3-4-10 SHEET 7 of 9

ALL THREAD

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				DEPARTMENT/PROCESS				MRB (QS1042)	
Date: _____		Sequence #: _____		QTY Affected : _____		Disposition					
Description Work Order Deviation						Completed By					
Root Cause						Lead hand / Supervisor					
Fault Category						QC / QA Coordinator					